

Work Order ID 53619

November 10, 2009 2:55:43 PM



Page 1

Item ID:	D2221	Accept		Setup	Start	
Revision ID:	H				Stop	
Item Name:	350 Basket Base					
Start Date:	11/10/09	Start Qty:	1.00	Cust Item ID:		
Required Date:	11/19/09	Req'd Qty:	1.00	Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2221	Rev H								

100 0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
 2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
 3- tack weld mesh on basket as per dwg D2221
 A/R ER316 S.S. Rod Batch: M109213

CE * Converted to Lit DSI 9473

PD 09.11.16

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53619

November 10, 2009 2:55:44 PM



Page 2

Item ID: D2221

Accept



Setup Start



Revision ID: H

Stop



Item Name: 350 Basket Base

Start Date: 11/10/09 Start Qty: 1.00



Cust Item ID:

Required Date: 11/19/09 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC6- Inspect dimensions to drawing

0.00

2) Sorulur

Memo

0.00



130



Powdercoat

Powder Coating

* PRESSURE WASH

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

M12142

0.00

Memo

0.00

1- Plug holes prior to

1ST COAT:

START TIME: 2:00pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 2:30pm

***** 2nd coat if necessary*****

2ND COAT:

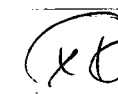
START TIME: 2:45pm

OVEN TEMPERATURE: 400°F

FINISH TIME: 3:15pm

el

02/11/19



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

[illegible]

November 10, 2009 2:55:44 PM

Accept



Setup Start

Stop

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

2. Once the problem is identified, the next step is to define the objectives and goals of the project. This helps to clarify what needs to be achieved and provides a clear direction for the team.

3. The third step is to develop a plan or strategy to address the problem. This involves breaking down the problem into smaller, manageable tasks and determining the resources needed to complete each task.

4. The fourth step is to implement the plan. This involves putting the strategy into action and monitoring progress to ensure that the project is on track.

5. The final step is to evaluate the results of the project. This involves assessing the outcomes against the objectives and goals and identifying any areas for improvement.

Cust Item ID:

Required Date: 11/19/09 **Req'd Qty:** 1.00

Customer:

Reference:

Run Start

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Operation Description

Set Up/ Run Hours

Draw Number	Draw Rev.	Plan Code
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**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

140

QC3- Inspect Part Finish

0.00

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QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: W/O 338 0.00

0.00

00000000000000000000

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/11/27 *[Signature]*

BY 09-11-27

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2009 2:55:41 PM

Page 1

Work Order ID: 53619

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base



Comments: ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Date: 11/10/09

Required Date: 11/19/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2221-1RevH		Manufactured	No			100	Each	14.0000	1.0000			
												
Rib												

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

1

48101

1

Main Warehouse

WA

13

51872

1

53213

12

PD 09.11.16

D2221-5RevH

Manufactured

No

100

Each

8.0000

2.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

8

53244

8

PD 09.11.16

D2221-7RevH

Manufactured

No

100

Each

4.0000

1.0000



Rib

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

4

53246

4

PD 09.11.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2009 2:55:41 PM

Work Order ID: 53619



Parent Item: D2221RevH

Parent Item Name: 350 Basket Base

Start Date: 11/10/09

Required Date: 11/19/09

Comments: ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2232-3RevC		Manufactured	No			100	Each	15.0000	2.0000			
Basket Hinge												

Handwritten signature
11/17

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

2

50024

2

Main Warehouse

WA

13

53344

13

Handwritten circled 2

D2235-1RevB1

Manufactured

No

100

Each

14.0000

2.0000



Basket Rib

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

10

53215

10

Main Warehouse

WA

4

50565

3

51871

1

Handwritten: AD 09.11.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2009 2:55:41 PM

Page 3

Work Order ID: 53619

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Comments: ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Date: 11/10/09

Required Date: 11/19/09

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2581RevA1  Mounting Bracket		Manufactured	No			100	Each	40.0000	2.0000			

Cpl 09/11/17

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 12

46086 2

48428 1

51120 9

Main Warehouse

WA 28

50872 1

51745 27

D3442-1RevA

Manufactured No

100

Each

8.0000

2.0000



Shim

② Cpl 09/11/17

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST 1

46767 1

Main Warehouse

WA 7

50951 7

②

November 10, 2009 2:55:41 PM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2009 2:55:42 PM

Work Order ID: 53619

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base


Start Date: 11/10/09

Required Date: 11/19/09

Comments: ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3825-041RevA		Manufactured	No			100	Each	4.0000	2.0000			
												
Rib Assembly (Basket End)												

Warehouse Loc Qty Loc Code
Location

Main Warehouse
WA
53381

53644 PD 09.11.16

D3826-041RevB		Manufactured	No			100	Each	4.0000	2.0000			
												
Rib / Gusset Assembly												

Warehouse Loc Qty Loc Code
Location

Main Warehouse
WA
53216

53500 PD 09.11.16

D3827-041RevA		Manufactured	No			100	Each	4.0000	1.0000			
												
Rib Assembly (Inboard)												

Warehouse Loc Qty Loc Code
Location

Main Warehouse
ST
53247

PD 09.11.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 10, 2009 2:55:43 PM

Work Order ID: 53619

Parent Item: D2221RevH

Parent Item Name: 350 Basket Base



Start Date: 11/10/09

Required Date: 11/19/09

Comments: ADD IDENTIFY AND STOCK DD 09.11.05 verified by:JLM

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3832-1RevA		Manufactured	No			100	Each	4.0000	1.0000			
												
Mesh (Base)												

lpl 09/11/17

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

2

46306

1

46774

1

Main Warehouse

WA

2

53218

2

D3833-1RevA

Manufactured

No

100

Each

6.0000

2.0000



Mesh (Base End Face)



①
lpl 09/11/17

Warehouse

Location

Loc Qty

Loc Code

Main Warehouse

WA

6

50025

2

53214

4

B53627 → ②

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

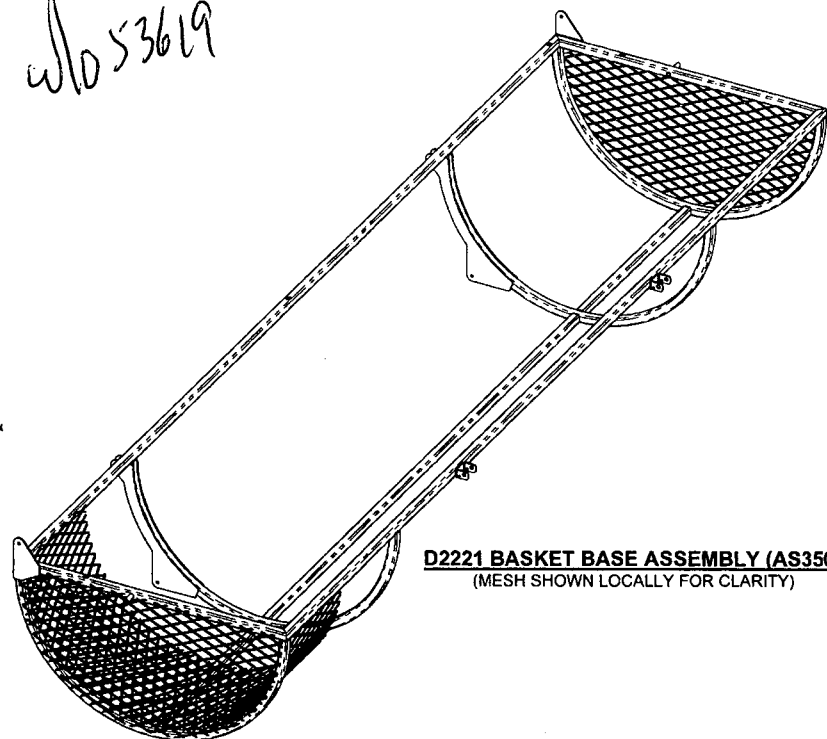
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W1053619



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

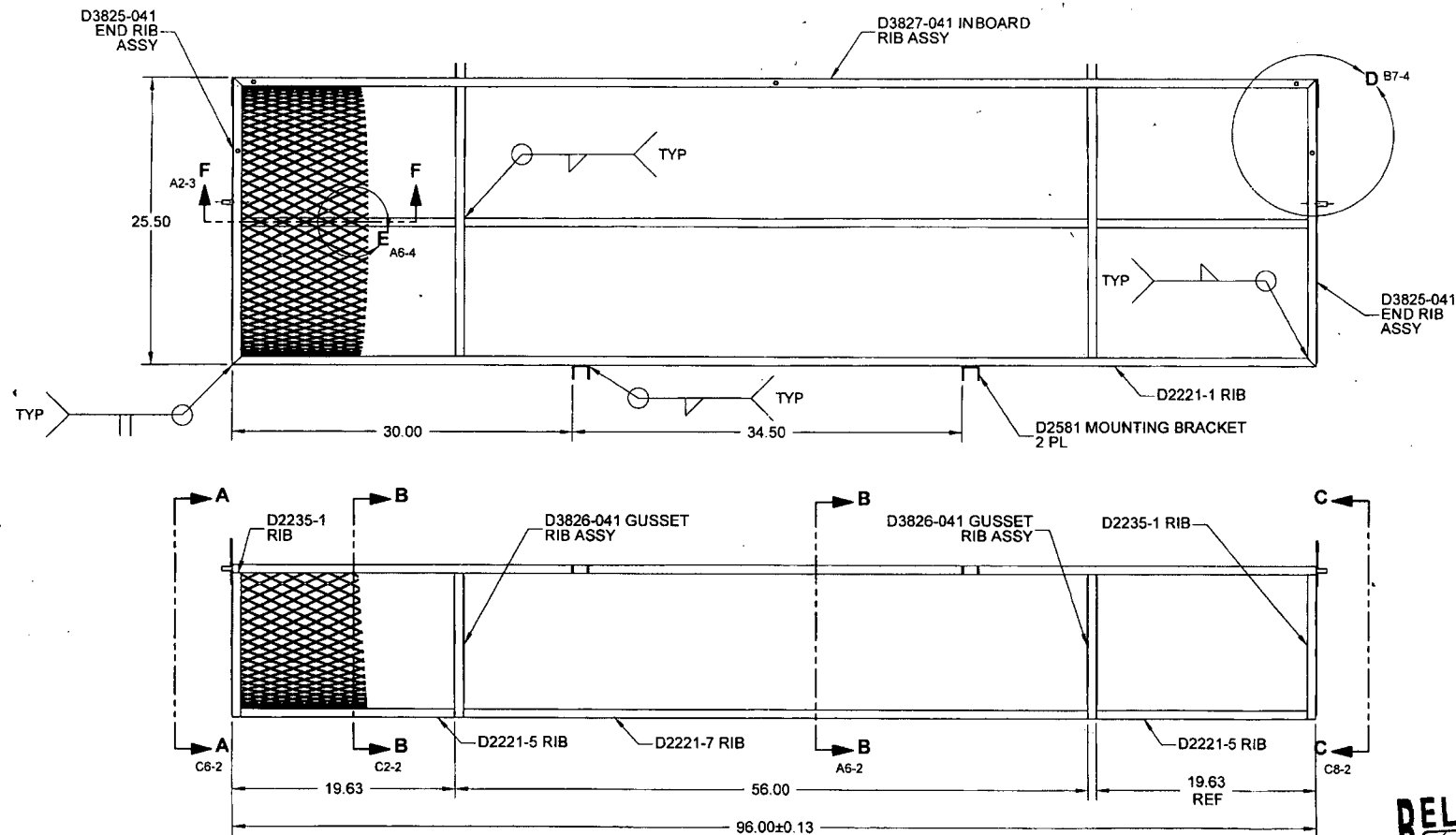
H

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D2221-5	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

RELEASED
08/11/18



H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN C6-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/-5/-7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE: ADD HOLES FOR SPLIT LID BASKET	PH	05.05.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	B		
CHECKED	JS	DRAWING NO.	REV. H
MFG. APPR.	JS	D2221	SHEET 1 OF 5
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small> COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. </small>	

cto 53619

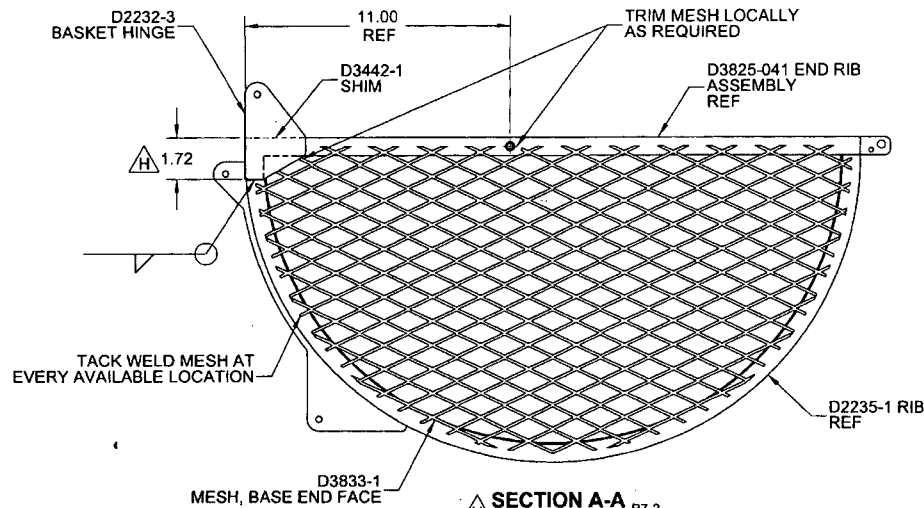


D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

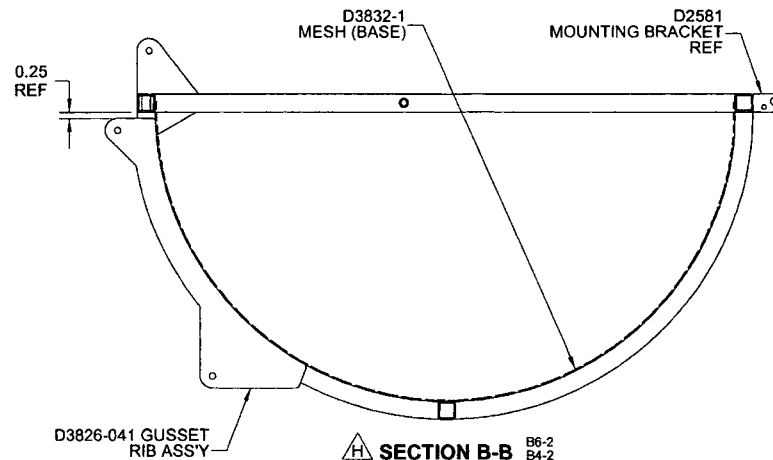
RELEASED
06/11/18

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.		SHEET 2 OF 5	
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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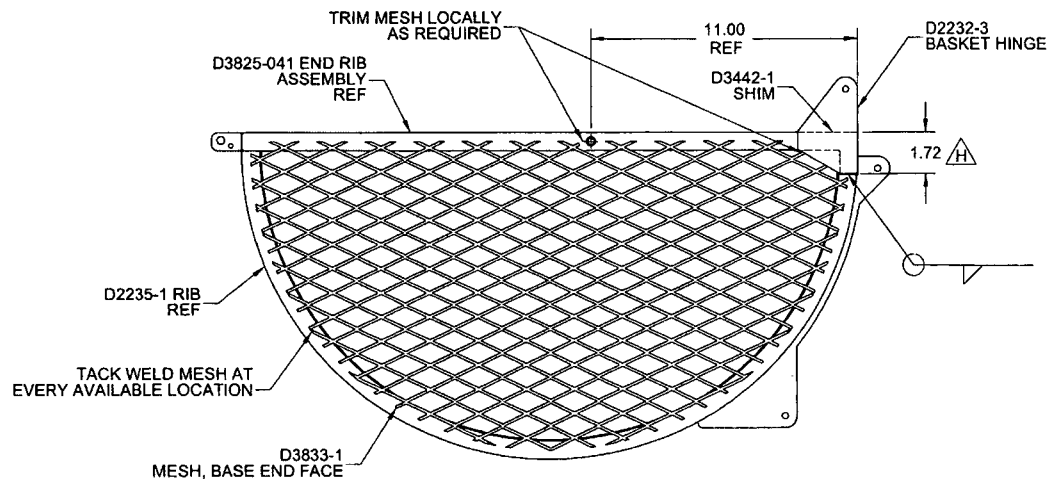
W/D 53619



SECTION A-A
SCALE 2X B7-2



SECTION B-B
SCALE 2X B6-2
B4-2
(D3833-1 MESH NOT SHOWN FOR CLARITY)



SECTION C-C
SCALE 2X B2-2

RELEASED

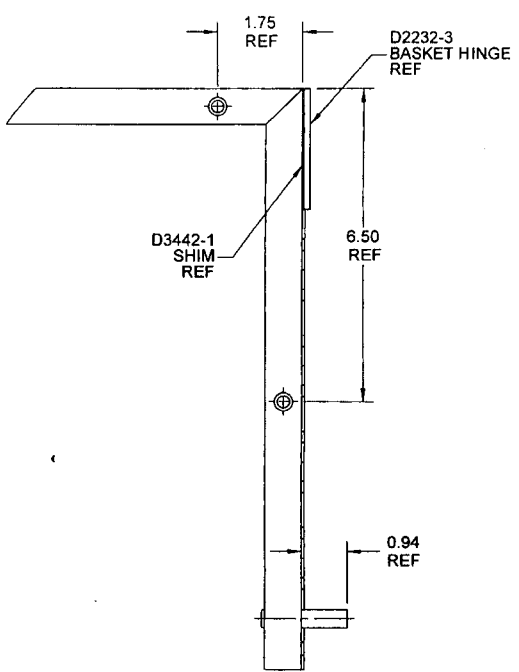
DESIGN	BW	DART AEROSPACE LTD	
DRAWN	4/3/18	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D2221	REV. H
MFG. APPR.		TITLE	SHEET 3 OF 5
APPROVED		BASKET BASE ASSEMBLY (350)	SCALE NTS
DE APPR.			
DATE	08.09.18		

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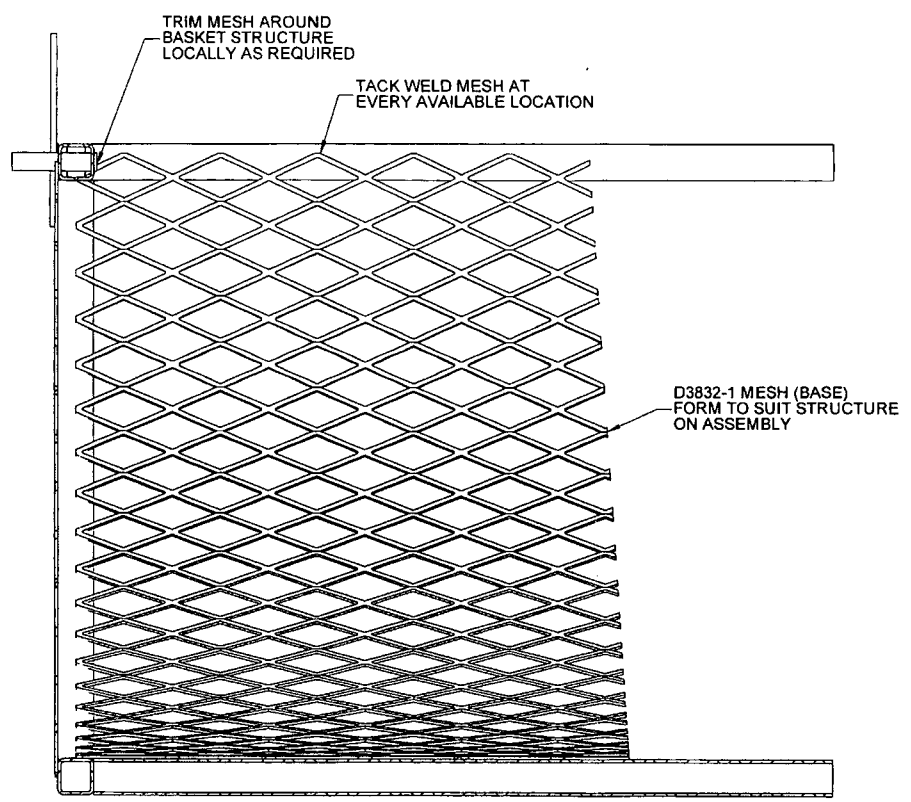
W/O 53619

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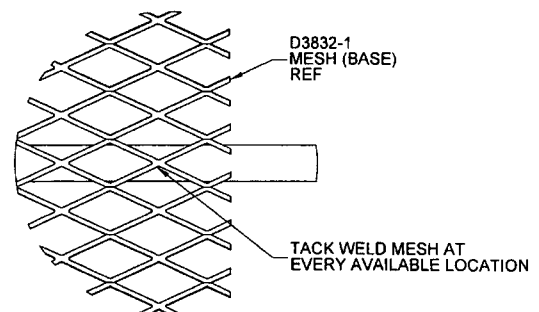
D
C
B
A



DETAIL D
SCALE 4X D2-2



SECTION F-F
SCALE 4X D7-2



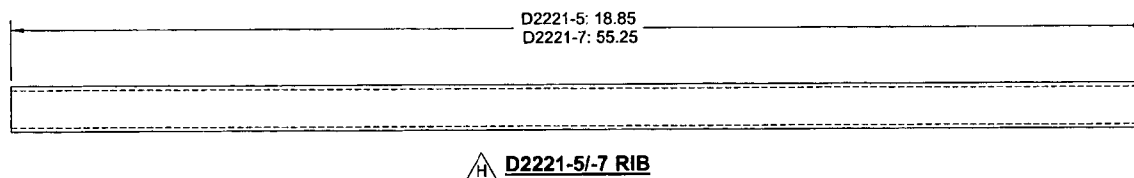
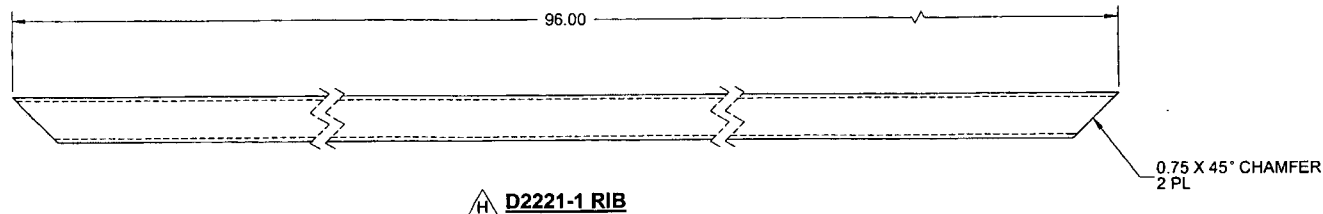
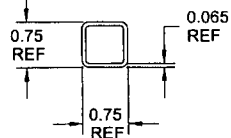
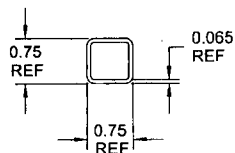
DETAIL E
SCALE 4X C6-2

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	MS	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 4 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
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8 7 6 5 4 3 2 1

W/O 3619



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- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 5 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350) NTS	
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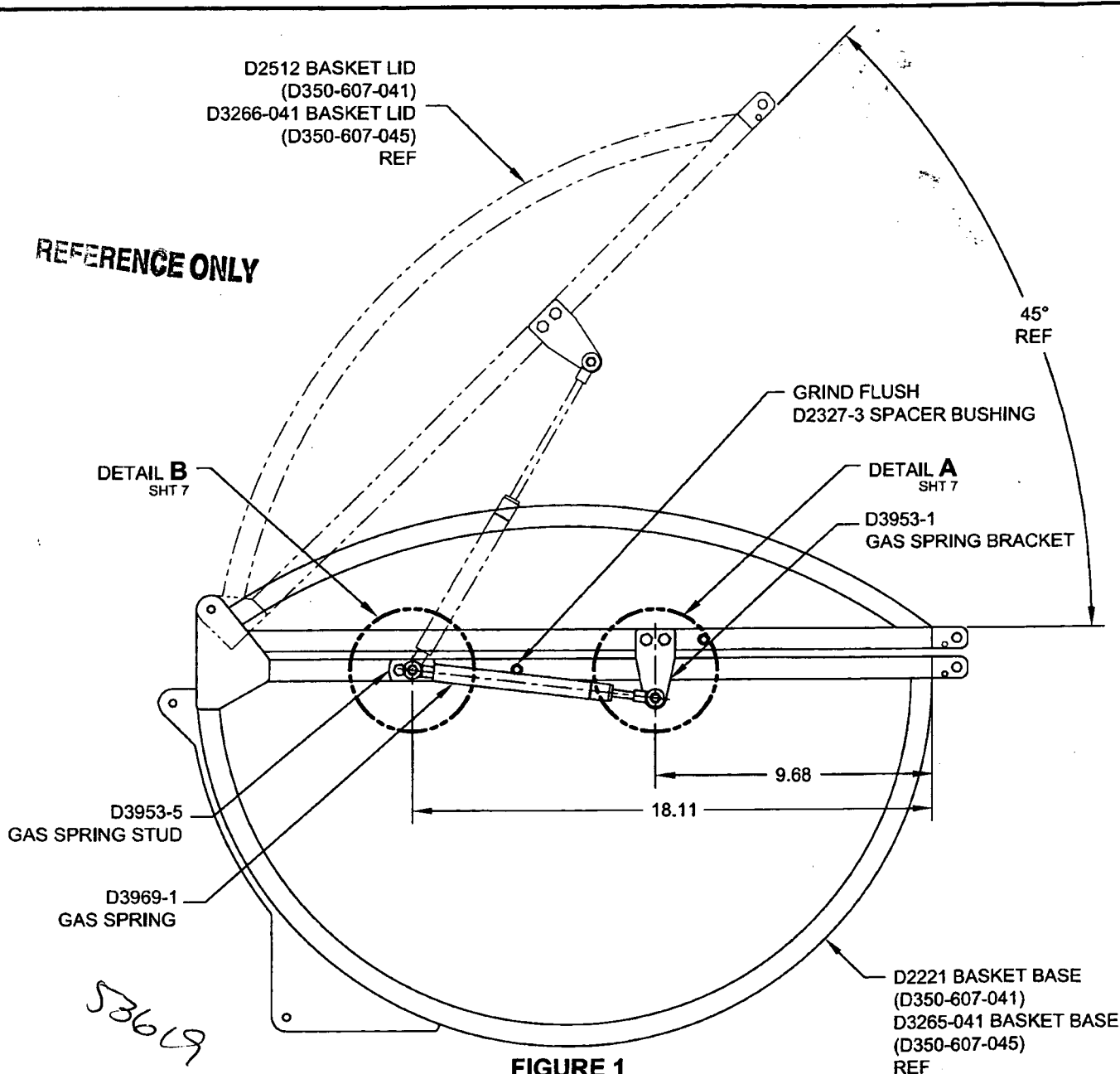


FIGURE 1

D350-607-141 AUTOMATIC LID OPENER INSTALLATION

(BOTH ENDS)

D350-607-145 AUTOMATIC LID OPENER INSTALLATION

(1 END ONLY)

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)
DATE: 09.11.06
CERT. NO.: SH94-14
ISSUE NO.: 4

DESIGN	AJS
DRAWN	AJS
CHECKED	<i>[Signature]</i>
MFG. APPR.	N/A
APPROVED	<i>[Signature]</i>
DE APPR.	<i>[Signature]</i>
DATE	09.11.06

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. DSI 9473
REV. B
SHEET 5 OF 8
TITLE AUTOMATIC LID OPENER INSTL
SCALE NTS

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